



Dart Aerospace Ltd.
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D3913-041
Job Sheet 183322



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/16/18

Job Tracking No:

Due Date: 10/5/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/5/18	0.00	0.00	Start Up Large Fab-5		<i>C 03-10-18</i>
100	Large Fab	1 pcs		10/5/18	0.00	10.00	Large Fab 1		<i>C 03-10-18</i>
110	QC	1 pcs		10/5/18	0.00	0.00	QC9		<i>My</i>
120	QC	1 pcs		10/5/18	0.00	0.00	QC5		<i>My</i>
125	HandFinish	1 pcs		10/5/18	0.00	0.29	HandFinish2		<i>* D.B. 18/10/09</i>
130	Powdercoat	1 pcs		10/5/18	0.00	0.93	Powdercoat2		<i>BK 18-10-10</i>
135	Packaging	1 pcs		10/5/18	0.00	0.00	Packaging1		<i>M 18-10-10</i>
140	QC	1 pcs		10/5/18	0.00	0.00	QC3		<i>M 18-10-10</i>
150	HandFinish	1 pcs		10/5/18	0.00	0.50	HandFinish4		<i>M 18-10-10</i>
160	QC	1 pcs		10/5/18	0.00	0.00	QC5		<i>M 18-10-10</i>
170	Packaging	1 pcs		10/5/18	0.00	0.00	Packaging3-2		<i>M 18-10-10</i>
180	QC21-SA	1 Ea		10/5/18	0.00	0.00	QC21		<i>3-30 OCT 10 2018</i> <i>DAS OCT 10 2018</i>

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M 83983 START: 8:30 OUT: 375° FINISH: 8:45.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	<i>005843</i>
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	<i>5097502</i>
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	<i>5112746</i>
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	<i>5093386</i>
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	<i>5096630</i>
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	<i>5108295</i>
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	<i>5104485</i>
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	<i>5109084</i>
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	<i>5114158</i>
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	<i>5110912</i>
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	<i>5110037</i> <i>5108326</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish
D2931	Bumper	2 Ea (2 ea)	150-HandFinish
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish

5109399
 5108590
 51095113926
 5109408
 5098052
 5093684
 5089298167
 F86435
 5676007
 50945921
 5103666-1
 5672828

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	90	0
	D3913-1	1	7	0
	D3913-15	1	22	0
	D3913-3	1	8	0
	D3913-7	2	16	0
	D3913-9	1	12	0
	D3916-041	2	18	0
	D3916-5	3	30	0
	D4016-1	3	10	0
	D4017-7	3	58	0
	D4017-9	2	20	0
	D4020-11	2	35	0
	D4021-1	3	55	0
	D4034-041	1	9	0
	D4034-043	1	9	0
	D4672-1	2	24	0
	M304EX0.75-16F	33	2,172	0
	AN3-10A	6	301	0
	D2931	2	958	0
	D4021-5	2	46	0
150-HandFinish	MS20600-AD4W3	2	357	0
	MS21042L3	6	3,288	0
	NAS1149F0332P	12	3,305	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Thermoforming ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Quality ☐ Other ☐																							
Date : _____		Step _____		DART AEROSPACE Part: D3913 - 041 Job No: 183322 Serial No/Batch: S115546 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 10/03/18 Container No: S115546 Job No: 183322 Serial No/Batch: S115546 DART AEROSPACE Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com																													
Description Work Order _____		_____																															
_____		_____																															
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td style="width:50%;">Environment ☐</td><td style="width:50%;">No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	Centre not concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Boiling route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
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